

Work Order ID 124020

124020

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September-05-14 1:42:46 PM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-05 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

record fwd angle: 85.10 DGC

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

SL Waste label

Mh-1

OCT 15 2014

DAS
38
9-89

14-10-15

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160	Skidtubes	0.00							
Skidtubes	<div><div><div><div><div><div>1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</div><div>2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.</div><div>3- Open float holes using uni-bit to .500" (4 per Side)</div><div>4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</div><div>5- Deburr and blow out all chips from inside of tube</div><div>6- Prepare tube for welding, remove alodine as required.</div><div>7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 122437 exp. date: 14-11-26</div><div>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: M129399</div><div>9- At section AP-AP drill out x-bolt spacer to 0.404"</div><div>10- Grind welds flush as per Dwg D2750</div><div>11- Spot face ground handling holes section (total of 4 places per side) as per</div></div></div></div></div></div>								

DBC 14-9-19

7 DEC 14-09-23
 14-9-23

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

14-9-23

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

① 1403.24

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 1409.24

DAS
9
9-89

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				1	2614925		
200 *200* SprayPaint Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 129568 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 129977	0.00 0.00				1			DAS 41 9-89 14-9-30
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Inspect for foreign object per QSI 024	0.00 0.00				x1Rt1	q	14/10/07	DAS 15 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--

230

HandFinish

Hand Finishing

Memo

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11129455

EXP DATE: 12/11

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11129305 1270 398 1311 11125792 041015106

5-Coat all exposed fasteners with "LPS Procyon"

batch: 11122900

240	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

240

QC

Quality Control

Memo

0.00

DAS
38
9-89

14-10-10

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									DAS
Packaging	Memo	0.00							06
Packaging									9-89
									OCT 15 2014
260	QC4- 100% Inspect kits for completeness	0.00							DAS
260									38
QC	Memo	0.00							9-89
Quality Control									OCT 15 2014
270	Packaging	0.00							
270									DAS
Packaging	Memo	0.00							06
Packaging	Package as per PPP D350-636-012								9-89
									OCT 29 2014

F6078

DAS
46
9-89

DAS
06
9-89

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

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Start Date: 9/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

14/11/3
MF
14-10-31

Picklist Print

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Page 1

Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured No

110

Each

1.0000

1

1

D2600-3-BENT

Extrusion Bent

**

DGC 11-9-5

Location

Loc Qty

Loc Code

LG002

123533

1

119680

1

D2744

Manufactured No

110

Each

53.0000

1

1

D2744

Cap

**

AFV 08-10

Location

Loc Qty

Loc Code

LG001

53

13128

52

115440

1

Picklist Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

**

DGC 11-9-17

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

**

BE14-09-22

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE14-09-22

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 100.0000 4 4

D3490-1

Cross Bolt Spacer

BE 14-07-22

Location

Loc Qty

Loc Code

LG

85

(A22457)

85

LG001

15

112737

1

116358

14

4

D3631-1 Manufactured No 230 Each 126.0000 8 8

D3631-1

Washer

del 10/10/2

Location

Loc Qty

Loc Code

FP001

126

110258

16

119553

10

123452

100

x 2

D3791-1 Manufactured No 230 Each 6.0000 1 1

D3791-1

Wearpad

del 10/10/2

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

5

118942

5

B120343

x 1

Picklist Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each 8.0000 1 1

D3793-3

Wearplate Aft

**

all 11/10/07

Location

Loc Qty

Loc Code

FP001

1

B123333

104212

1

xl

FP002

7

120141

7

MS21043-6

Purchased No

230 Each 58.0000 4 4

MS21043-6

NUT

**

all 11/10/07

Location

Loc Qty

Loc Code

FG

20

103693

20

M130325

ST306

38

m127255

6

m127813

32

D3794-1

Manufactured No

230 Each 2.0000 1 1

D3794-1

Gasket Fwd

**

all 11/10/07

Location

Loc Qty

Loc Code

FP001

2

B123497

109207

1

xl

93381

1

Picklist Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

NAS1611-010

O-RING

ell 11/10/02

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

✓ 8

D2741

Manufactured

No

250

Each

48.0000

1

D2741

Blade

DAS
38
9-89

DAS
06
9-89

OCT 15 2014

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

1

NAS1515H3L

Purchased

No

230

Each

293.0000

4

4

***NAS1515H3I ***

Washer

ell 11/10/02

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

xy

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Shop Packet Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

**

ell 11/10/02

Location

Loc Qty

Loc Code

FP001

140

m128375

72

m129430

68

80

AN3C6A

Purchased

No

230

Each

1,058.0000

4

4

AN3C6A

Bolt

**

ell 11/10/02

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

4

NAS1149C0832R

Purchased

No

230

Each

258.0000

1

1

NAS1149C0832R

Washer

**

ell 11/10/02

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

1

Picklist Print

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Work Order ID: 124020

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each 15.0000 1 1

D3536-25

Gasket Center

**

all wh1067

Location

Loc Qty

Loc Code

FG	6	B124099	x1
87053	2		
95328	4		
FP001	9		
110652	1		
123300	7		
93696	1		

D3794-3

Manufactured No

230 Each 11.0000 1 1

D3794-3

Gasket Aft

**

all wh10107

Location

Loc Qty

Loc Code

FP001	11		
111457	8		x1
122529	2		
92658	1		

AN3C5A

Purchased No

230 Each 140.0000 34 34

AN3C5A

Bolt

**

all wh10107

Location

Loc Qty

Loc Code

FG	5	B130358	x34
122800	5		
ST350	135		
M128911	27		
M128973	10		
M129913	98		

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

93.0000

3

3

D3537-1

Wearpad

all 10/10/07

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

75

113839

4

120644

52

120645

18

93945

1

x3

D3535-25

Manufactured No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

all 10/10/07

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

22

110744

1

123415

20

93278

1

x1

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

142.0000

8

8

D3492-3

Plug

**

ll 9/10/07

Location

Loc Qty

Loc Code

FP001

142

104853

24

107331

1

112739

1

115807

6

118977

10

123464

100

B124020

x 0

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

**

ll 9/10/07

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

x 30

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

16.0000

1

1

D3488-042

Blade Fitting RH

**

lll 11/10/07

Location

Loc Qty

Loc Code

FP001

15

115599

7

120135

7

98887

1

FP002

1

112237

1

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

258.0000

38

38

AI S4-1032-225

Rivnut

* ALS7-1032-225

**

lll 11/10/07

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST267

228

M127028

10

M127092

26

M128179

192

D3492-1

Manufactured No

230

Each

121.0000

8

8

D3492-1

Plug

**

lll 11/10/07

Location

Loc Qty

Loc Code

FP001

121

111578

2

114879

7

119646

2

120519

50

122460

60

x2
x6

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

**

ll 11/10/07

Location

Loc Qty

Loc Code

FP002

11

112741

2

120212

8

92382

1

xl

AN8C35A

Purchased

No

230

Each

73.0000

1

1

AN8C35A

Bolt

**

ll 11/10/07

Location

Loc Qty

Loc Code

FG

4

121275

4

11128798

xl

FP001

69

m126293

29

m127823

1

m130114

39

MS21083C8

Purchased

No

230

Each

64.0000

1

1

MS21083C8

Nut

**

ll 11/10/07

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

xl

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

145.0000

8

8

D2745

Bushing

lll 11/10/07

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

x 8

AN6C44A

Purchased No

230

Each

45.0000

4

4

AN6C44A

Bolt

lll 11/10/07

Location

Loc Qty

Loc Code

FG

2

103964

2

ST333

43

m128319

2

m128700

1

m129199

40

14

D3532-1

Manufactured No

250

Each

34.0000

2

2

D3532-1

Spacer

DAS
38
9-89

DAS
86
9-89

OCT 15 20

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

2

Picklist Print

September-05-14 1:42:49 PM

Page 13

Work Order ID: 124020

124020

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

64.0000

2 2

DAS

MS21083C8

**

130358

06

9-89

Nut

DAS

38

9-89

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

NAS1149D0863J

Purchased

No

250

Each

795.0000

2 2

DAS

NAS1149D0863J

**

06

9-89

Washer

DAS

38

9-89

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

ST2776

200

125635

200

D3493-1

Manufactured

No

250

Each

139.0000

2 2

D3493-1

**

DAS

06

9-89

Washer

DAS

38

9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

OCT 15 2014

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Page 14

Work Order ID: 124020

124020

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

62.0000

2 2

AN8C21A

DAS
38
9-89

**

DAS
06
9-89

Bolt

Location

Loc Qty

Loc Code

OCT 15 2014

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

2

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALST-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, AL ODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø.027) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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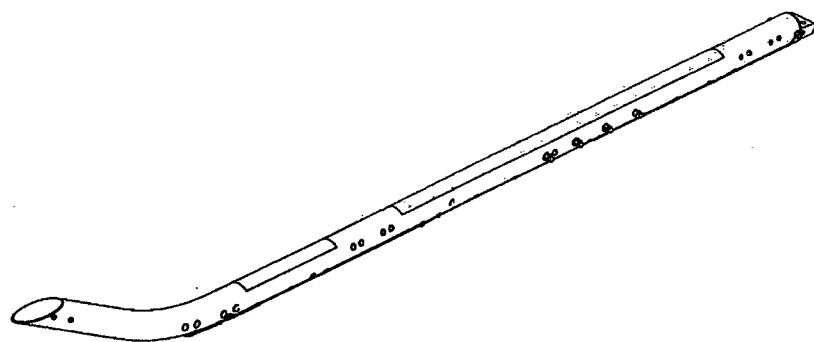
14-09-05
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2013-08-13
WD

G	CORRECTED TOLERANCE ON Ø.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE QTY UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.			
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DE APPR.			
DATE	13.07.11		

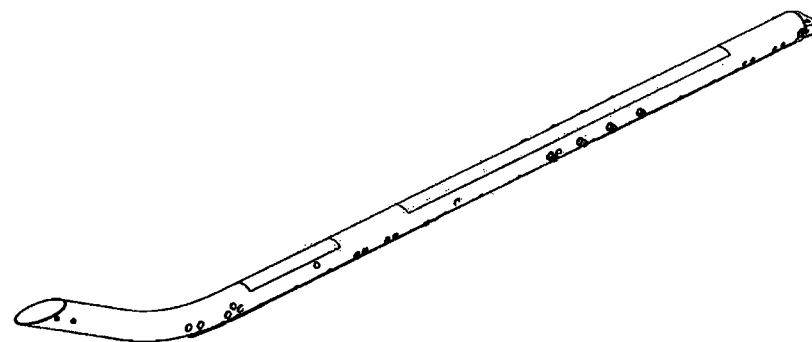
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KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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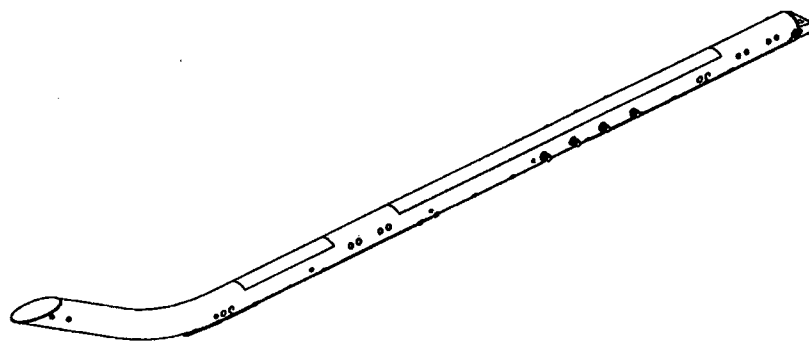
D2750-041 350 SKIDTUBE ASSEMBLY, LH



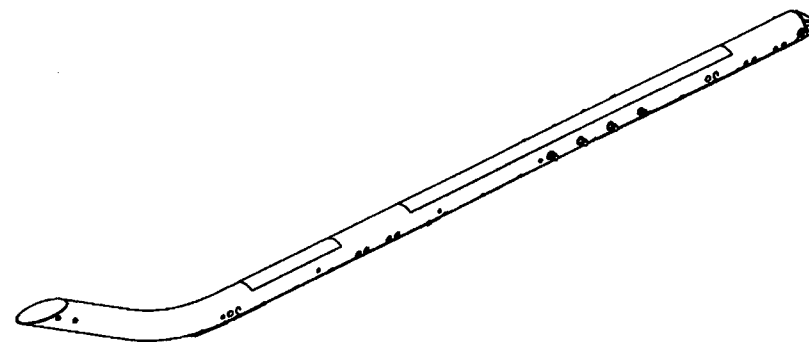
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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7

6

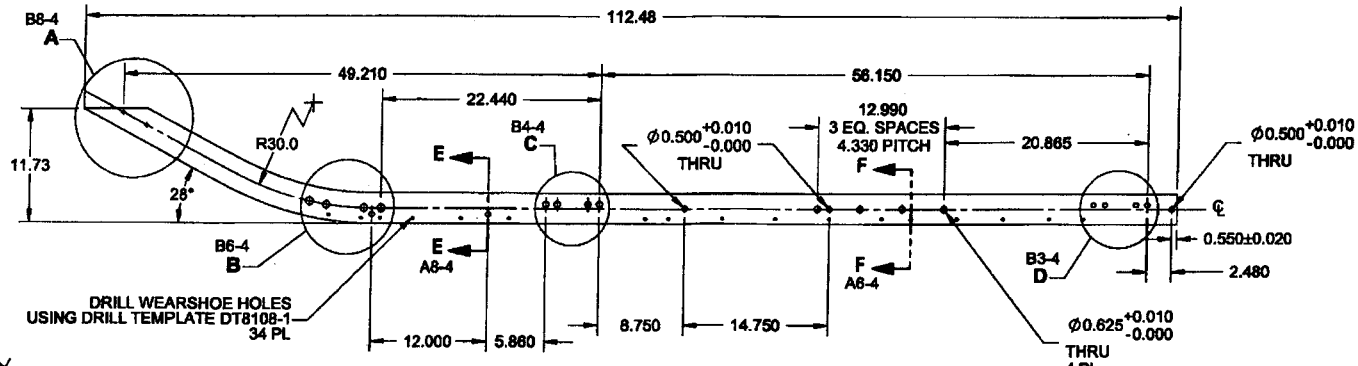
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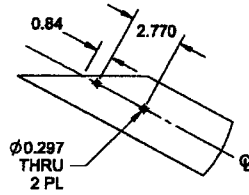
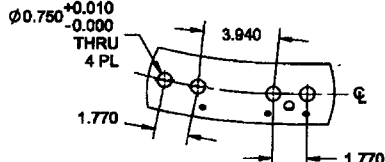
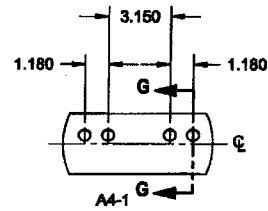
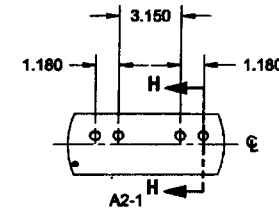
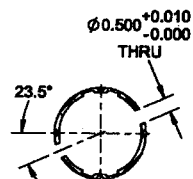
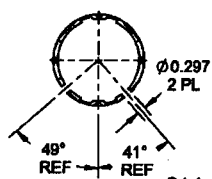
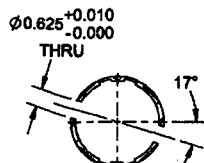
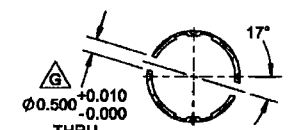
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2

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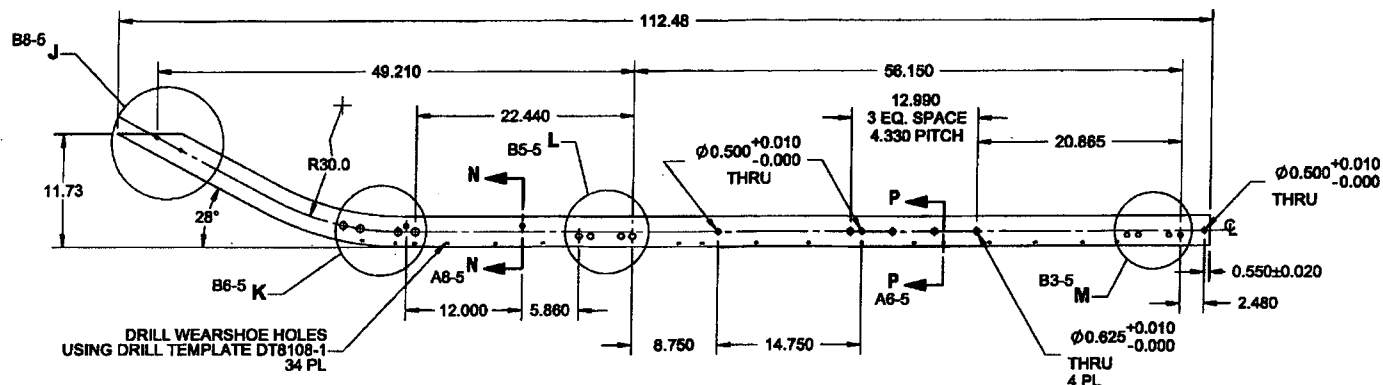


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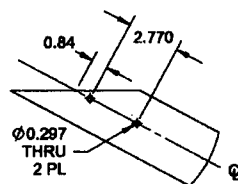
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SCALE 2XDETAIL B
SCALE 2XDETAIL C
SCALE 2XDETAIL D
SCALE 2XSECTION E-E
SCALE 3X, 2 PLSECTION F-F
SCALE 3X, 17 PLSECTION G-G
SCALE 3X, 4 PLSECTION H-H
SCALE 3X, 4 PL

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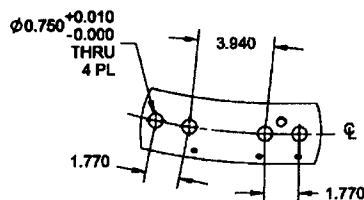
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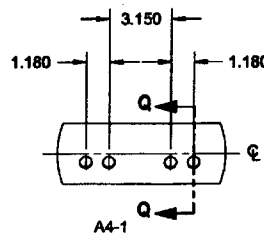
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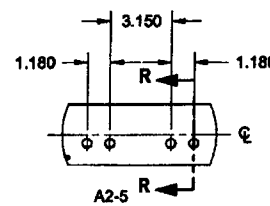
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DETAIL J
SCALE 2X



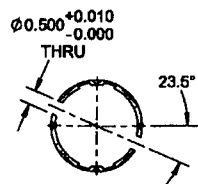
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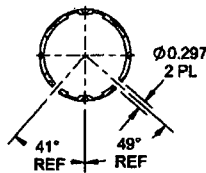
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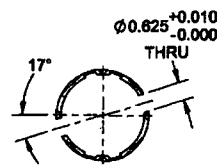
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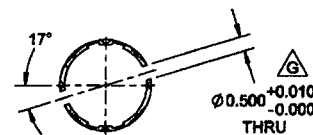
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C4-5
SECTION P-P
SCALE 3X, 17 PL



B5-5
SECTION Q-Q
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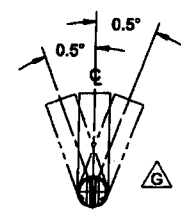
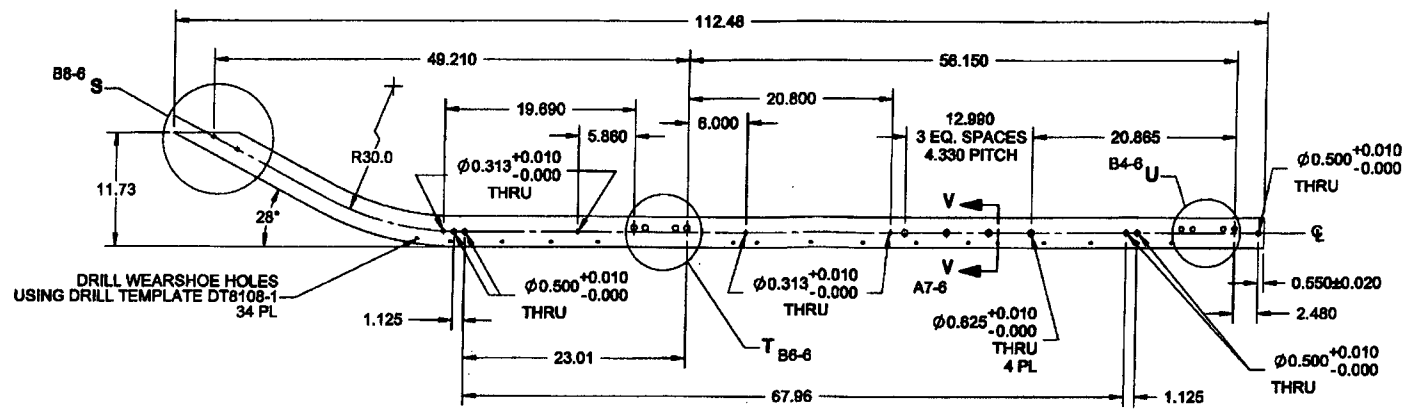


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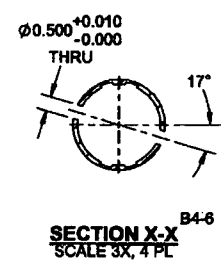
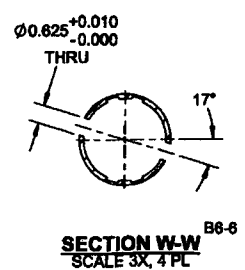
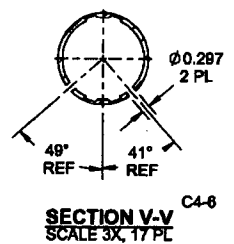
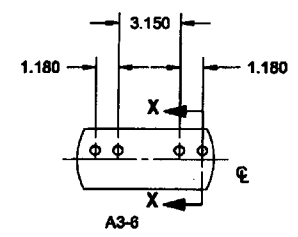
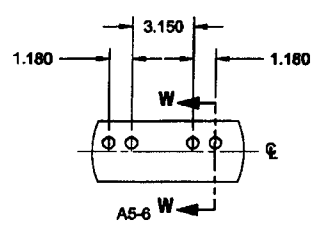
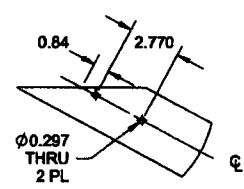
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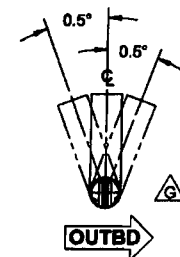
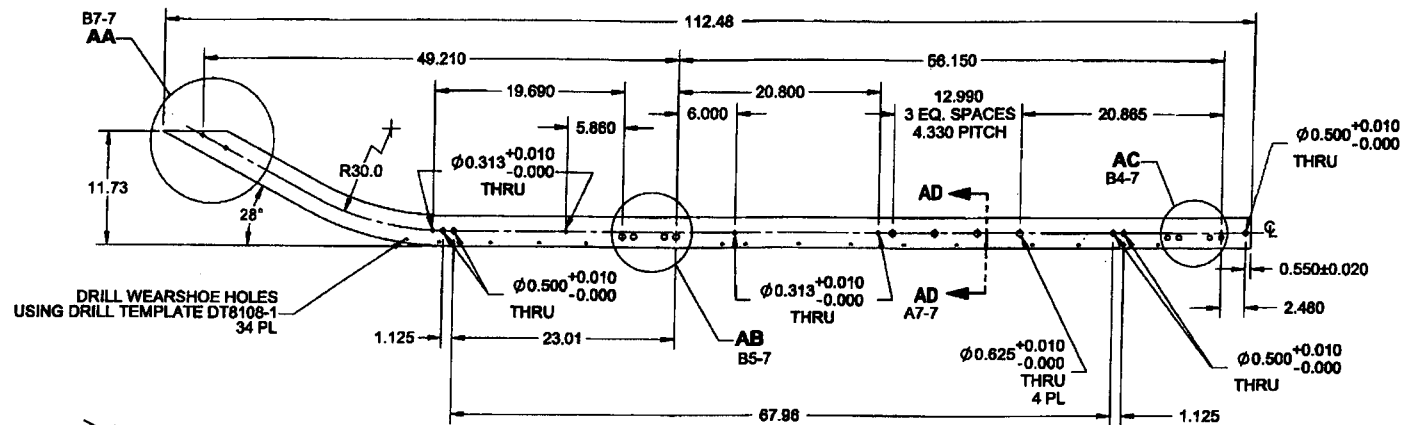
D2750-3 LH SKIDTUBE



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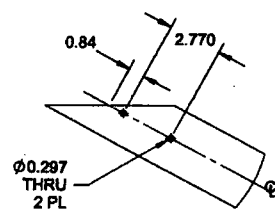
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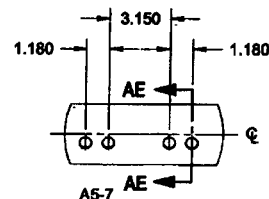


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

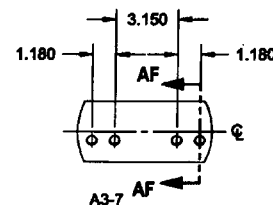
D2750-4 RH SKIDTUBE



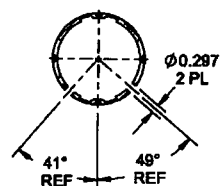
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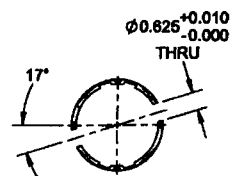
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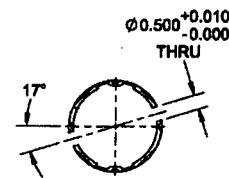
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



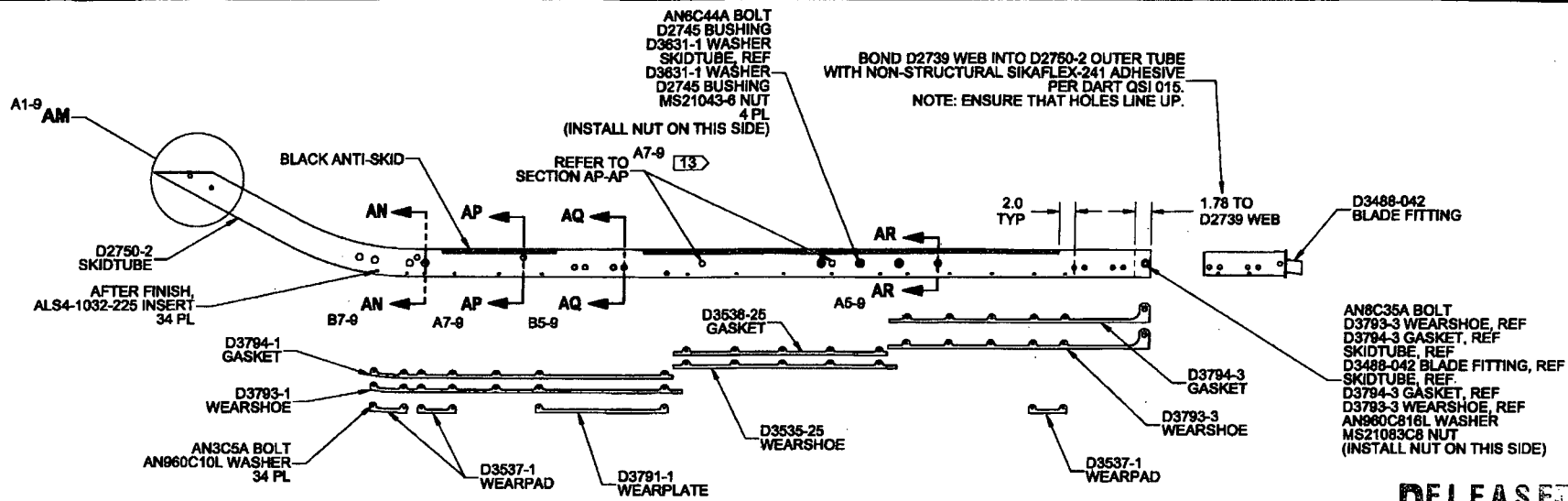
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SCALE 3X, 4 PL

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CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	13.07.11	SCALE NTS

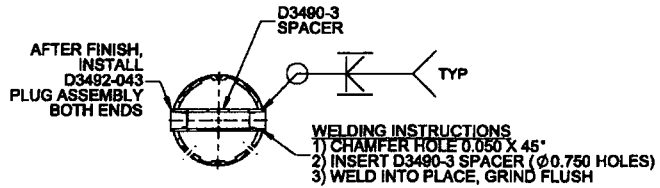
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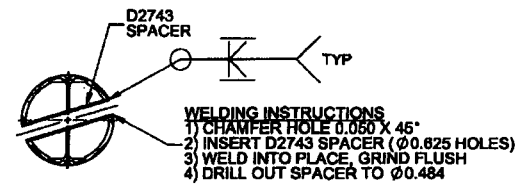


D2750-042 350 SKIDTUBE ASSEMBLY, RH

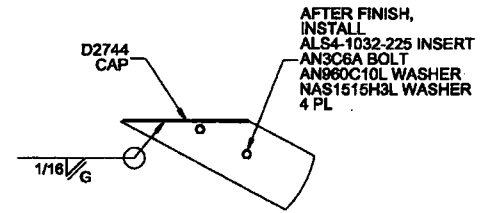
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2013-08-13



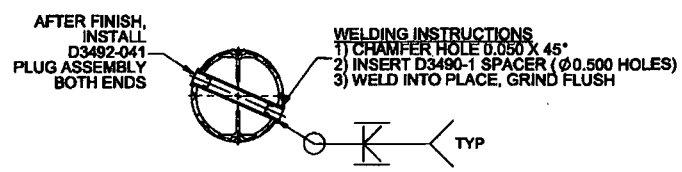
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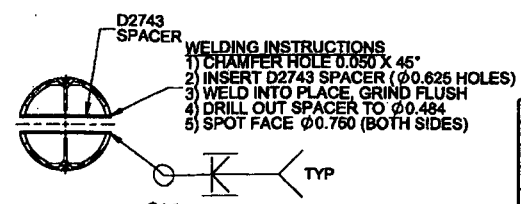
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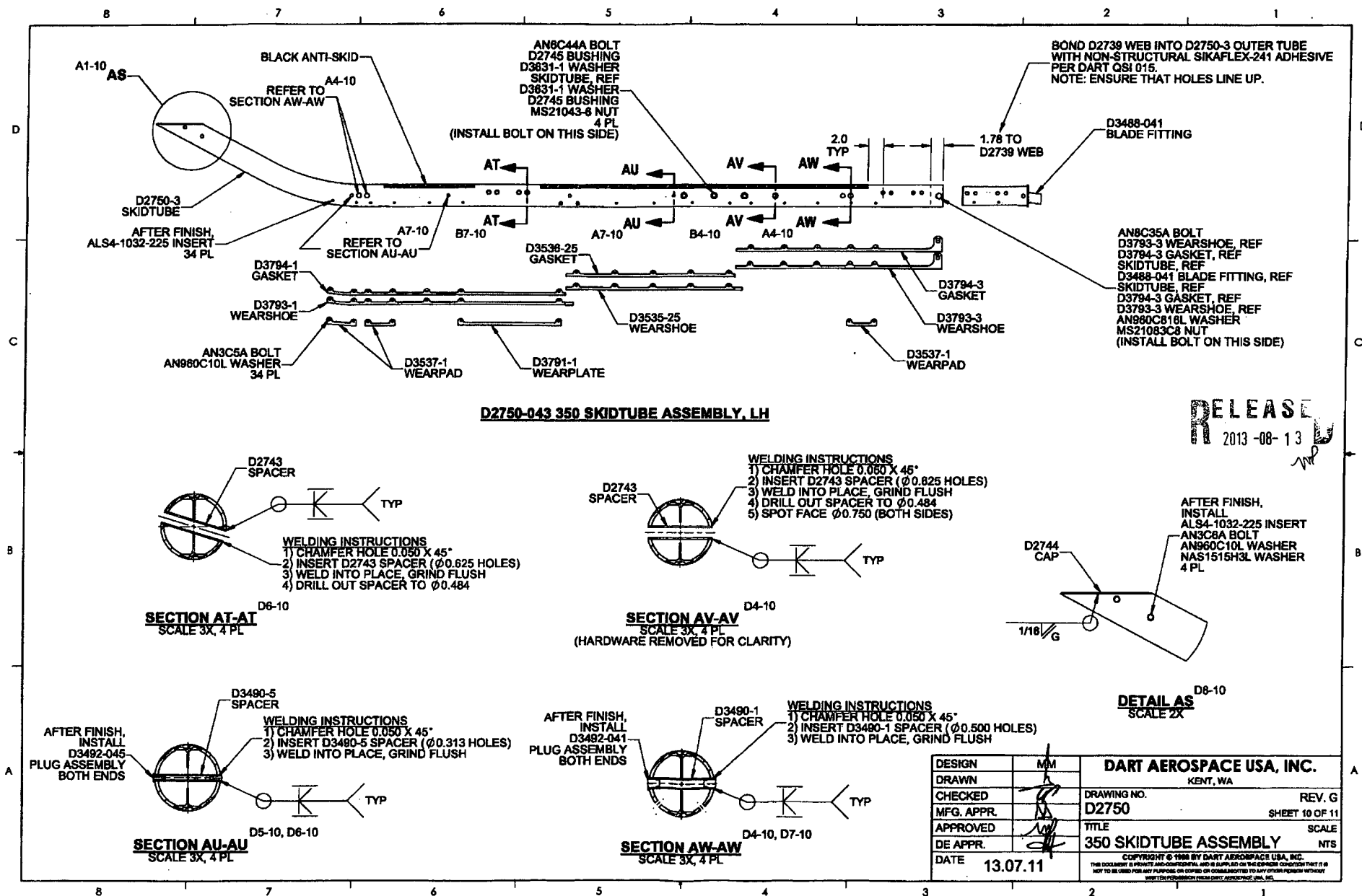
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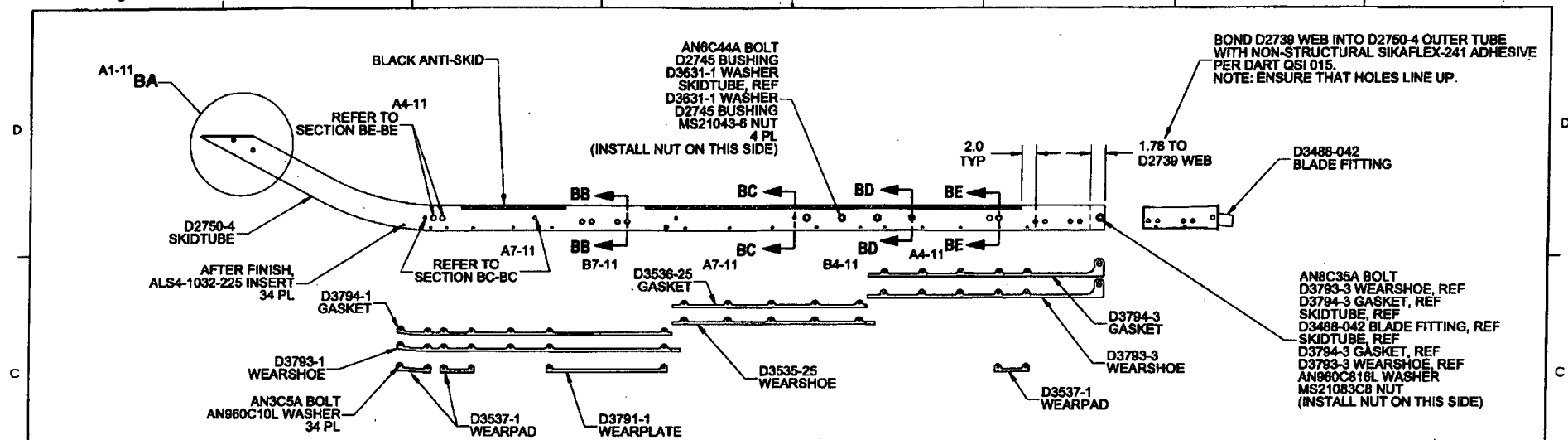
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(HARDWARE REMOVED FOR CLARITY)

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DRAWN		KENT, WA	
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MFG. APPR.		D2750	SHEET 9 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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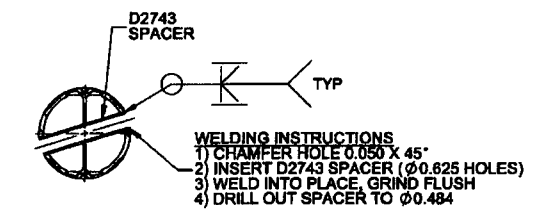
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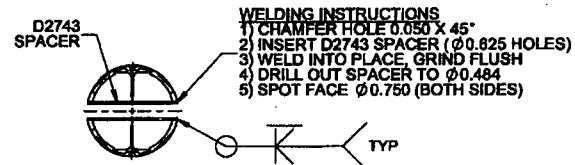
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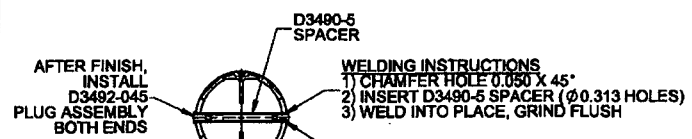
D2750-044 350 SKIDTUBE ASSEMBLY, RH



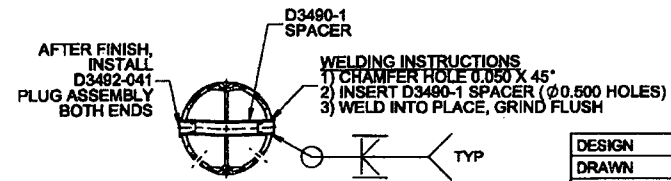
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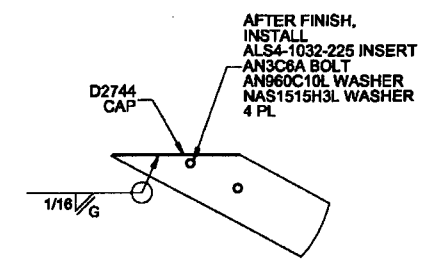
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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